

Work Order ID 132073

Friday, April 24, 2015 10:34:34 AM

132073

Page 1

Item ID: D4044-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Rib Assembly
Start Date: 4/27/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/27/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 1504-24 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4044	A								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 60" and remove identification markings
- 2- Bend tube with manuel pipe bender as per template DT9579 (Make first line at 15.00")
- 3- Drill and chamfer holes in D4044-1 using DT8995 as per dwg D4044
- 4- Trim access tube material to finish size as per dwg D4044
- 5- weld bushing as per dwg D4044
- A/R S.S. rod Batch: 11123
- 6- grind welds flush M130267

1xDAS
43
9-89**APR 28 2015**

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Quality Control

Memo

0.00

1xDAS
24
9-89**APR 28 2015**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120									
QC	Memo	0.00				1x		DAS 24 9-23	APR 28 2015
Quality Control									
130	Identify as per dwg & Stock Location: <u>WJA 04</u>	0.00							
130									
Packaging	Memo	0.00				1x		DAS 43 9-89	APR 28 2015
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

APR 29 2015

MLJ APR 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

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132073

Parent Item: D4044-041

D4044-041

Parent Item Name: Fwd Rib Assembly

Start Date: 4/27/15

Required Date: 4/27/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	141.0000	3	3			

D3759-1

Bushing

**

DAS

43

APR 29 2015

Location

Loc Qty

Loc Code

WA004

141

116816

69

117449

8

129746

22

130893

42

D4021-9

Manufactured

No

100

Each

122.0000

4

4

D4021-9

Bushing

**

DAS

43

9-89

APR 29 2015

Location

Loc Qty

Loc Code

WA004

122

120334

2

122601

4

123427

38

128879

21

129869

40

130981

17

M304TS0.750W.049

Purchased

No

100

f

1,134.575

5

6

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

DAS

43

9-89

APR 29 2015

Location

Loc Qty

Loc Code

WA004

1134.575

M130871

89.4

M131128

450.175

M131868

595

5 feet

DQA: _____ Date: _____

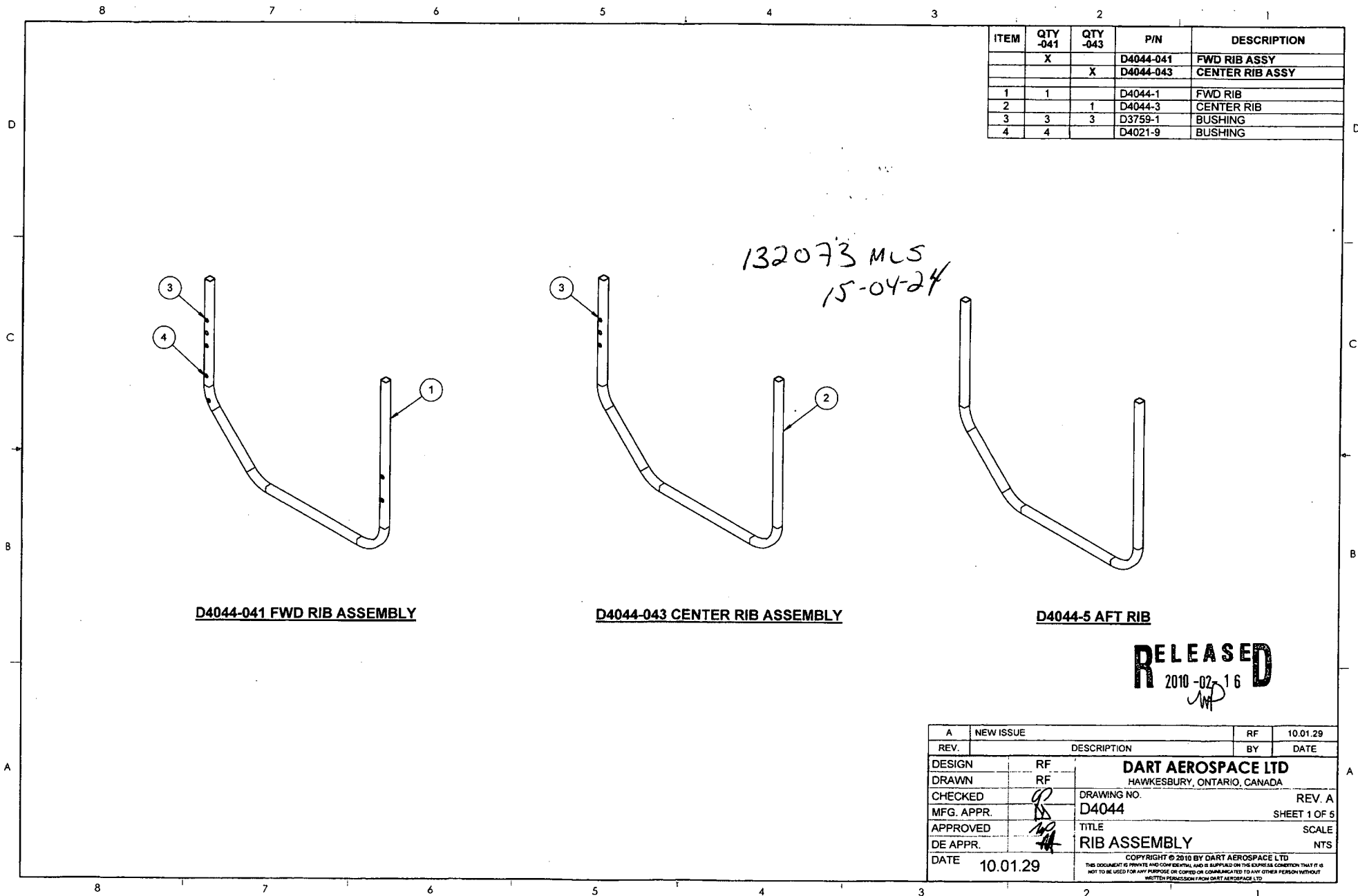


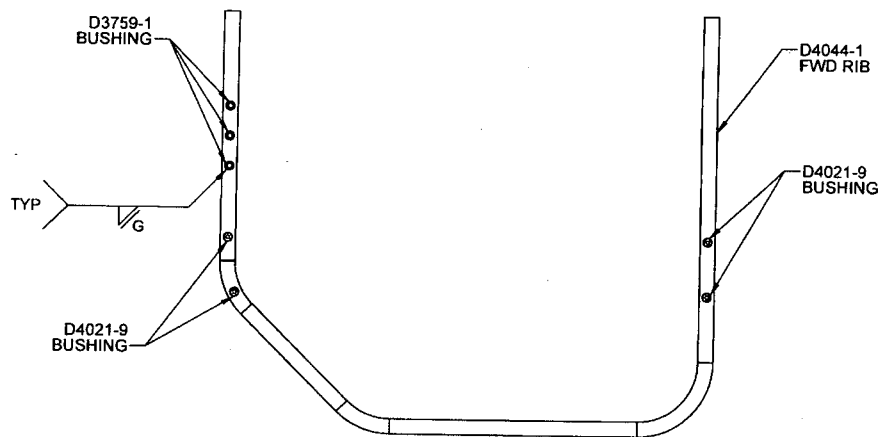
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

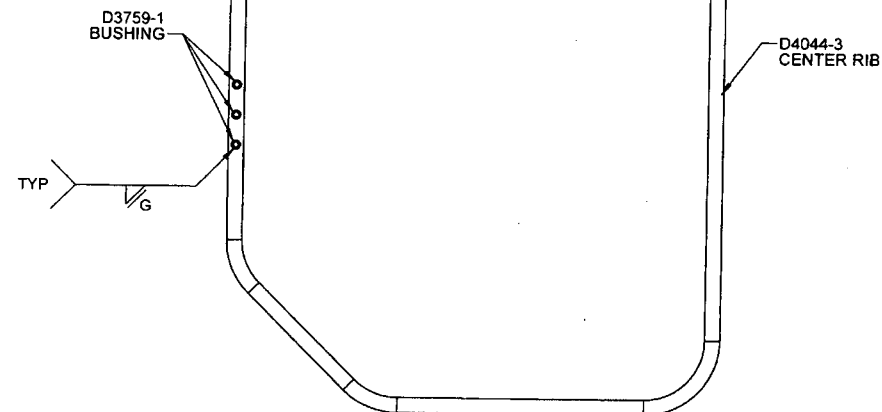
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D4044-041 FWD RIB ASSY



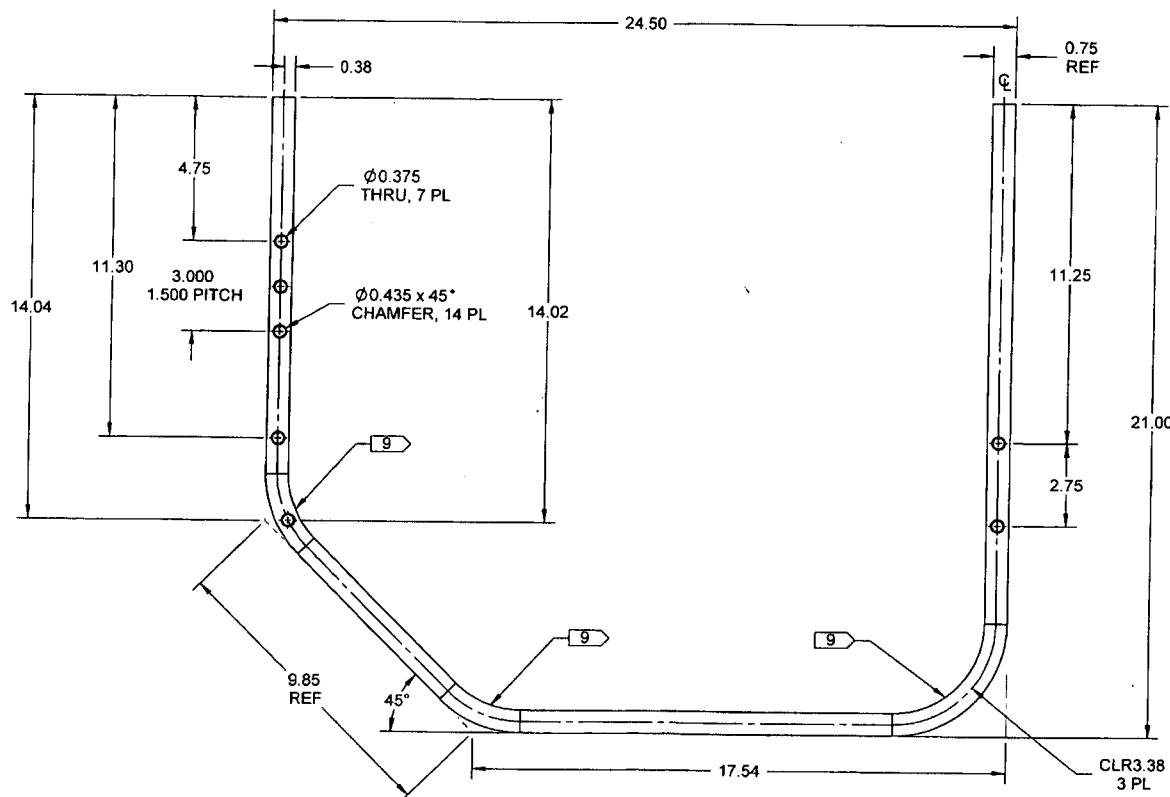
D4044-043 CENTER RIB ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4044-041: 2.29 lbs
D4044-043: 2.24 lbs
- 8) WELD PER DART QSI 004

RELEASED
2010-02-16
MP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4044	REV. A
MFG. APPR.	<i>RF</i>	SHEET 2 OF 5	
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	RIB ASSEMBLY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4044-1 FWD RIB

RELEASED
2010-02-16
WP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.750 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.19 lbs
- 8) TUBE FLAT LENGTH 59.31 REF
- 9) ALLOWABLE WRINKLING IN BENDS UP TO 0.15" DEEP MAX

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>JP</i>	DRAWING NO. D4044	REV. A
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APPROVED	<i>JP</i>	TITLE RIB ASSEMBLY	SCALE NTS
DE APPR.	<i>JP</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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